

205H.

Work Order ID 110093

December-17-13 9:14:50 AM

110093

Page 1

Item ID: D2348

Accept

N19000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate (Key Way)

Start Date: 12/17/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-12-19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2348	Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2348

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

30

0

Ac
14.01.11

6041.063"

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

30

0

Ac
14.01.11

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9.89

14/1/13

30

count

Work Order ID 110093

December-17-13 9:14:50 AM

110093

Page 2

Item ID: D2348 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate (Key Way)
 Start Date: 12/17/13 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
150									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: <u>22622</u> Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached								
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control	INSPECT CERTS								

CX 14/01/15 (30)

30x 14-1-17. DAS 26 9-89

30x 14/1/13

December-17-13 9:14:50 AM

1 10093

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/17/13 **Start Qty:** 30.00 ***30***

Cust Item ID:

Required Date: 12/17/13 **Req'd Qty:** 30.00 ***30***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

180

Small Fab

0.00

Small Fab

Memo

Small Fab

Install Insert as per Dwg D2348

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

Quality Control

0.00

200

Identify as per dwg & Stock Location: 5008 0.00

0.00

200

Packaging

Memo

Packaging

0.00

DAS
36
9-89

DAS
26
9-89

Work Order ID 110093

December-17-13 9:14:50 AM

110093

Page 4

Item ID: D2348

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate (Key Way)

Start Date: 12/17/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

14-01-2214-01-21

December-17-13 9:14:50 AM

Required Qty: 30.00

Comments:	IPP Rev A	Removed from 9 Digit	05-12-05	JLM
	IPP Rev:B	Now on Waterjet	06-07-03	JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3996-FE-832-EF		Manufactured	No			180	Each	97.0000	4	120			
Self-Clinching Fastener													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		97							
				82502		46							
				85727		34							
				96038		17							
M6061T6S.063		Purchased	No			100	sf	738.8065	0.0198	0.625263			
6061-T6 .063 Sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		738.8065							
				123135		120.2625							
				124003		70.943							
				M124446		94							
				M126075		77.742							
				M127006		148.99							
				M127420		226.869							

+ .005
- .001

+ .005
- .001

+ .005
- .001

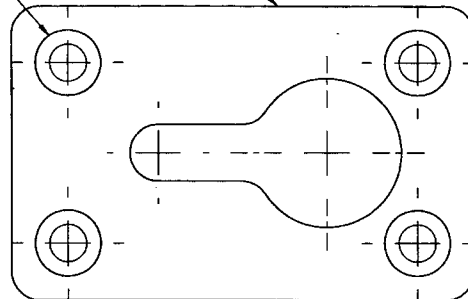
~~DAS~~
~~27~~
~~9-89~~

[illegible]

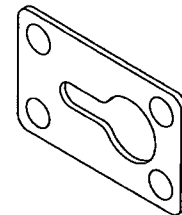
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

D2348F



D2348 WEAR PLATE



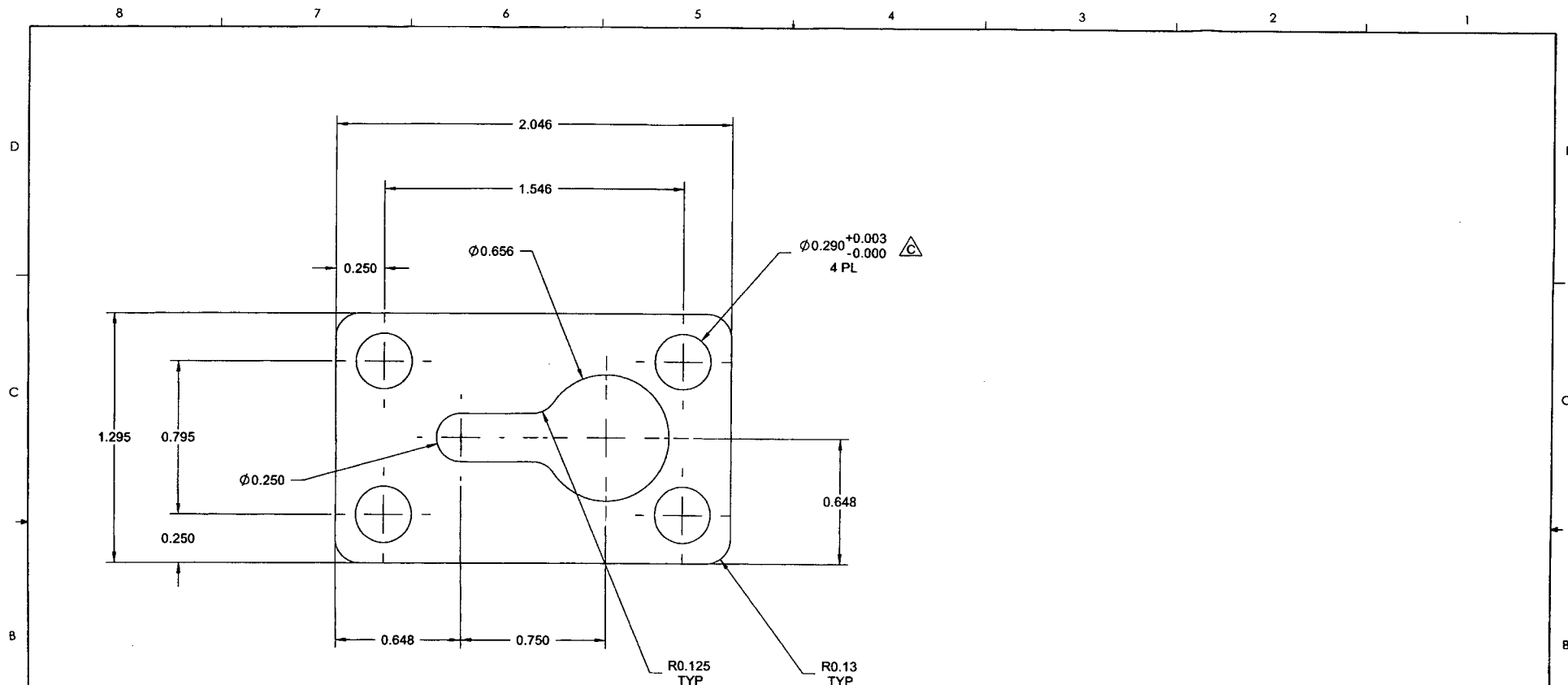
110093 MCG
13-12-19

RELEASED
2009-11-09
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. C
MFG. APPR.	DS	D2348	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2348F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III/IV CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

RELEASED
2009 -11- 08
MD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MD</i>	DRAWING NO. D2348	REV. C
MFG. APPR.	<i>MD</i>	SHEET 2 OF 2	
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62830

Date: 17-Jan-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST Rev: 2 PCS D4410-043 (6.25) 30 PCS D2348 (0.95) BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 PRICE IS PER PIECE Job: 20140035 PO: 22622 Line:		
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>17/1/14</u></p> <p>CERTIFIED SIGNATURE: <u></u></p> <p>RECEIVER SIGNATURE: _____</p>			